

Work Order ID 146352

Tuesday, December 06, 2016 9:30:08 AM

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Item ID: D4034-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Upper Rib Assembly
Start Date: 6/17/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 6/21/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: **DAS 21** Date: **DEC 06 2016** Tooling: Date: Run Start ***NR1***
QC: **9-89** Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4034	C								

100 Weld per dwg A/R S.S. rod Batch: **134102** 0.00***100***

Large Fab

Memo

0.22

Large Fab

1- Assemble ribs to hoop and weld as per dwg DT9564

2- Weld bushing in rib as per dwg

4 **C** **16-12-07**

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Memo

0.00

Quality Control

4x **DAS 43** **9-89** **DEC 09 2016**

120 QC5- Inspect part completeness to step on W/O 0.00

120

QC

Memo

0.01

Quality Control

4x **DAS 43** **9-89** **DEC 09 2016**

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>WNA 04</u>	0.00							
130									
Packaging	Memo	0.01				<u>4x</u>	<u>43</u>	<u>9-89</u>	<u>DEC 09 2016</u>
Packaging	LOCATION: WA004								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.07					<u>21</u>	<u>9-89</u>	<u>DEC 12 2016</u>
Quality Control									

DAS
21
9-89

DEC 09 2016

Picklist Print

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Work Order ID: 146352

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Parent Item: D4034-043

D4034-043

Parent Item Name: Fwd Upper Rib Assembly

Start Date: 6/17/2016

Required Date: 6/21/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC IPP Rev:B as
per dwg revA 10.03.15 verified by:EC IPP Rev:C 11.01.19 AS
PER DWG REV.B DD VERF:EC IPP Rev:D 13.03.14 AS PER DWG
REV.pc1 DD VERF:JLM IPP Rev:E 13.06.21 DWG REV.C DD
VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4021-7		Manufactured	No			100	Each	6.0000	1	4			
✓ *D4021-7*													
Hoop													

Location

WA004

151757
152507

Loc Qty

6

2

4

Loc Code

B151757 → 2x
B151099 → 2x

D4021-9		Manufactured	No			100	Each	188.0000	4	16			
✓ *D4021-9*													
Bushing													

Location

WA004

145800
152261

Loc Qty

188

2

186

Loc Code

B152261

D4034-1		Manufactured	No			100	Each	16.0000	1	4			
✓ *D4034-1*													
Rib													

Location

WA004

152155
152156

Loc Qty

16

12

4

Loc Code

B150385 → 1x
B150386 → 3x

B

Picklist Print

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Work Order ID: 146352

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Parent Item: D4034-043

D4034-043

Parent Item Name: Fwd Upper Rib Assembly

Start Date: 6/17/2016

Required Date: 6/21/2016

Start Qty: 4.00

Required Qty: 4.00

D4034-3

Manufactured

No

100

Each

5.0000

1

4

✓ ***D4034-3***

Rib

B152155**

4r C 16-12-07

Location

Loc Qty

Loc Code

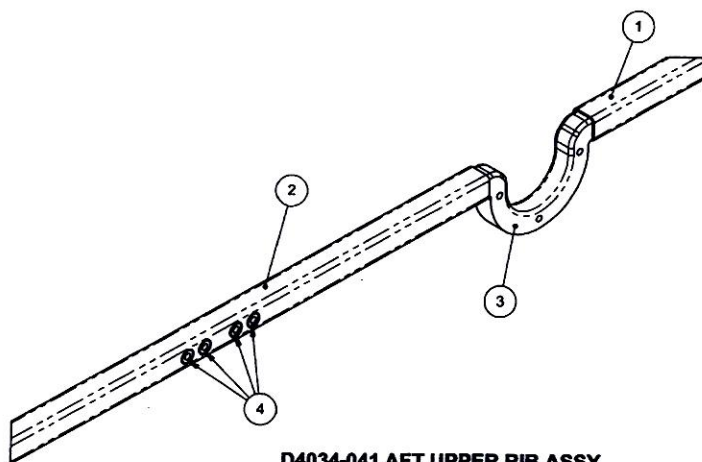
WA004

5

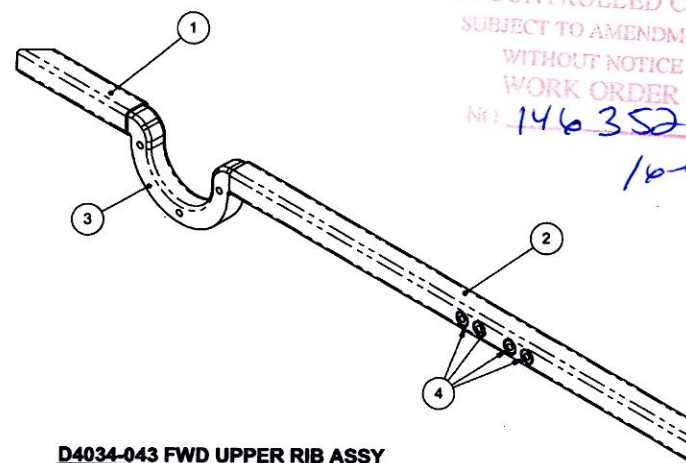
150385

5

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1	1	D4034-3	RIB
3	1	1	D4021-7	HOOP
4	4	4	D4021-9	BUSHING



D4034-041 AFT UPPER RIB ASSY



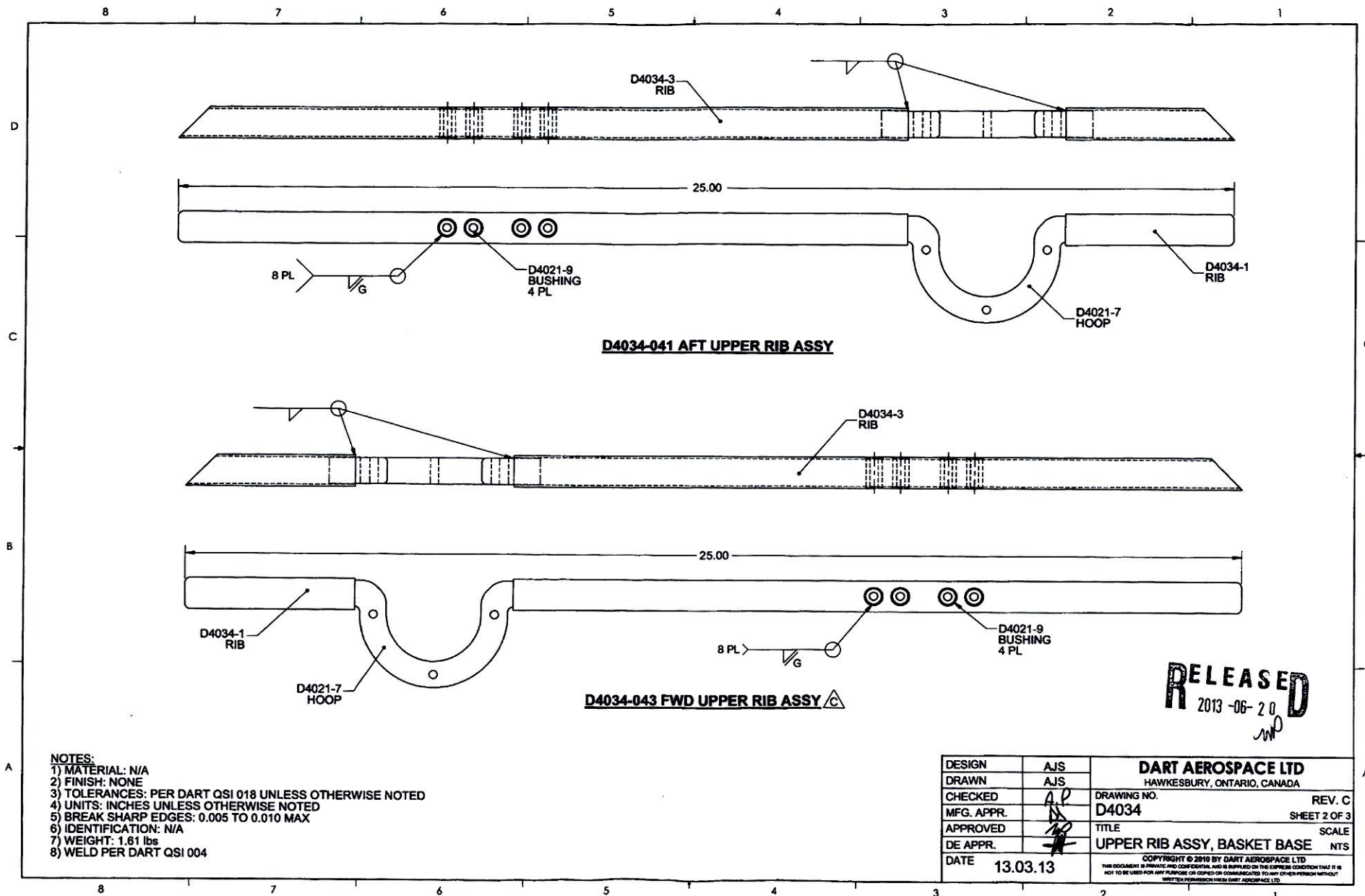
D4034-043 FWD UPPER RIB ASSY

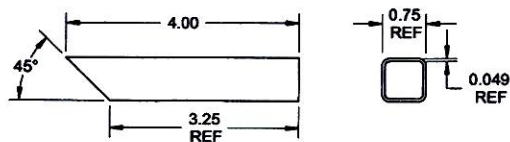
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 146352 MLJ
16-05-18

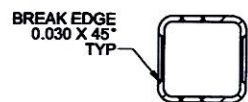
RELEASED
2013-06-20
M

C	-043 REDESIGNED AS MIRROR IMAGE OF -041. -5 DELETED. D2327-3 DELETED. REASON PROP ARM NO LONGER OFFERED.		AJS	13.03.13
B	ADDITIONAL HOLES ADDED ON D4034-3 RIB		SC	10.12.20
A	NEW ISSUE		AJS	10.03.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED	A.P.	DRAWING NO.	D4034	REV. C
MFG. APPR.	AS	SHEET 1 OF 3		
APPROVED	AP	TITLE	UPPER RIB ASSY, BASKET BASE	SCALE NTS
DE APPR.	AS	COPYRIGHT © 2010 BY DART AEROSPACE LTD		
DATE	13.03.13	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. WHO IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

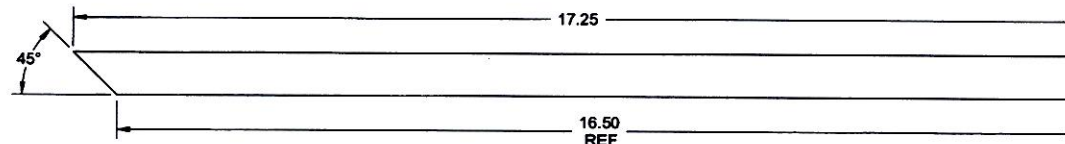
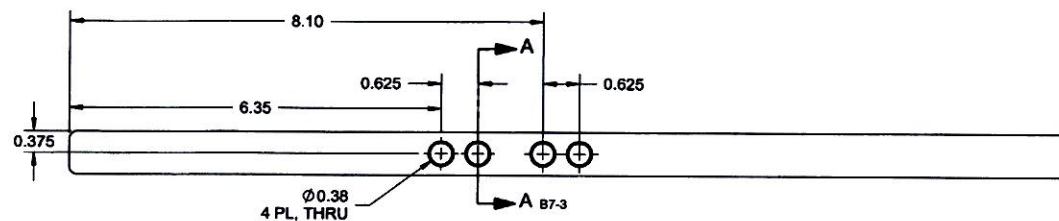




D4034-1 RIB



SECTION A-A C3-3



D4034-3 RIB

RELEASED
2013-06-28

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs
-3: 0.62 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO. D4034	REV. C
MFG. APPR.	AS	TITLE	SHEET 3 OF 3
APPROVED	AP	SCALE	NTS
DE APPR.	AP	UPPER RIB ASSY, BASKET BASE	
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